

## CORDURA® Fabric Brand Certification Requirements

NILIT® is a global leader in polyamide 6.6 production and we are focused on delivering high quality products and innovation to our customers around the world. CORDURA® fabric provides tough, durable service with high tear and abrasion resistance. CORDURA® fabric for apparel can be made in a range of weights and constructions, from lightweight fabrics for summer activewear shirts and shorts, to heavier fabrics for snow sports and motorcycle apparel.

We have a wide range of performance fibers under the CORDURA® brand name, check out our website <https://www.nilit.com/fiber/licensed-brands/cordura/> or call one of the contacts detailed at the bottom of this page.

**Using the CORDURA® brand could not be easier, just follow the 4 easy steps: -**

1. Fabric developed with CORDURA® fabric products should be submitted for testing using the form on the back of this document to our certification test laboratory.
2. We will confirm in writing the results of the certification testing, and if the fabric meets the Brand Certification Requirements for the requested end uses detailed below, a unique reference number will be provided with the approval certificate.
3. The fabric mill can then identify their fabric samples as CORDURA® fabric for the approved end uses and garment manufacturers can request free hangtags by quoting the unique fabric approval reference number. Applications for hangtags by garment makers can be made directly on our Internet site [www.nilit.com/hangtags](http://www.nilit.com/hangtags).

**Quality Standards:** Garment manufacturers are responsible for garment quality and together with the fabric producers, for ensuring that fabrics are suitable for their intended end use. NILIT reserves the right to withdraw the CORDURA® fabric brand from any fabric or garment that is of inferior quality. CORDURA® fabric quality standards vary by fabric type and intended end use, and are detailed below in a series of tables.

**Table 1** gives the CORDURA® fabric performance standards for woven fabrics (excluding motorcycle).

WOVEN FABRICS	LIGHTWEIGHT OUTERWEAR	LIGHTWEIGHT WORKWEAR (CONSUMER APPAREL)	READY TO WEAR	OUTERWEAR	WORKWEAR (CONSUMER APPAREL)	DENIM
CORDURA® Qualifying Yarns – in Warp	90f34 AJT180f68 Semi Dull AJT180f68 Full Dull AJT	90f34 AJT 180f68 Semi Dull AJT 180f68 Full Dull AJT	Min. 90 dtex AJT	Min. 180 dtex AJT	Min. 180 dtex AJT	---
CORDURA® Qualifying Yarns – in Weft	22f14,33f14 flathigher tenacity	22f14, 33f10 flat higher tenacity	Min. 90 dtex AJT	Min. 180 dtex AJT	Min. 180 dtex AJT	Min. 180 dtex AJT
Qualifying Yarn Content	50%	100%	40%	40% when combined with other nylon yarns 50% with all other yarns	100% 50% with cotton only	35%
Staple yarns allowed?	No	No	Yes	Yes	Cotton only	Yes
Abrasion. (modified Martindale)	500 cycles	500 cycles	500 cycles	500 cycles	600 cycles	500 cycles
Grab Strength	---	---	300N	900N, or 600N if staple present in fabric or 180 dtex in the weft	900N, or 600N if cotton present, or 180 dtex in the weft	900 N in weft 600 N in warp
Pilling Rating	---	---	5 4-5 if staple present	5 4-5 if staple present	5 4-5 if staple present	---

**Table 2** gives the construction recommendations for woven CORDURA® fabric in terms of the min. ends and picks.

DECITEX	MINIMUM WARP ENDS/CM	MINIMUM WEFT PICKS/CM
90	50	36
180	38	24
370	24	15
560	19	13.5
370/2	16	13
560/2	13	10.5

**Table 3** gives the performance standards for CORDURA® fabric in circular knit and flat bed fabrics.

KNIT FABRICS	
Qualifying Yarns	All Cordura® qualifying yarns
% Content Qualifying Yarns	100% minimum on fabric face minimum 50% total fabric content
Staple Yarns Allowed	No
Abrasion (Modified Martindale)	500 cycles
Grab Strength	120N
Snagging Rating	4-5

NOTE: All enquiries regarding CORDURA® fabric warp knits should be made directly to INVISTA  
 NOTE: CORDURA® fabric branding requirements for socks are detailed in a separate document

**Table 4** gives the performance standards for motorcycle suits and reinforcements

<b>Motor Cycle Suits &amp; Reinforcements</b>	
Qualifying Yarns - warp	Minimum 560 decitex
Qualifying Yarns - weft	Minimum 560 decitex
Qualifying Yarns Content	100%
Staple yarns allowed	No
Construction	Must be coated
<b>Coated Fabrics</b>	
Abrasion (Modified Wyzenbeek)	1,000 cycles
Grab Strength	1600 N
Tear Strength	90 N
<b>Lightly Coated Reinforcements</b>	
Abrasion (Modified Wyzenbeek)	700 cycles
Grab Strength	1600 N
Tear Strength	90 N

### **Performance Tests**

#### **Abrasion: Modified Martindale (BS EN 530)**

Fabrics are mounted on an abrasion machine that rubs multi-directionally for the prescribed number of cycles, or until two threads in either warp or weft have been worn away. The abradant material is P800 silicon carbide, with no weight on the test sample.

#### **Abrasion: Modified Wyzenbeek (TM 1507-90)**

Required only for motorcycle-wear. Fabrics are mounted on an abrasion machine that rubs in the warp and weft direction for the prescribed number of cycles, or until both a warp thread and a weft thread have been worn away.

#### **Pilling (BS EN ISO 12945-1)**

For fabrics containing staple yarns. Fabric samples are wrapped around a tube and then placed in a cork lined box where they are tumbled for 10 hours. The samples are then assessed against standard photographs that illustrate pilling ratings. A rating of 5 is excellent and a rating of 1 is poor.

#### **Snagging (INVISTA test method TCWM445)**

Required for all knit fabrics. Fabric samples are fitted around a tube and rotated while a spiked mace continually plucks the fabric. Snagging performance is assessed after 600 revolutions. A rating of 5 is excellent and a rating of 1 is poor.

#### **Grab Strength (ASTM D5034)**

Fabric samples are mounted in a tensile testing machine and extended until they break.

#### **Tear Strength (ISO 4674-1: Trouser Tear Method)**

This test measures the force required to tear a fabric sample along a pre-made cut. The average peak load (in Newtons) between two set points is reported

### **Terms and Conditions**

- Garment manufacturers are responsible for garment quality and for ensuring, along with the fabric producer, that the fabric is suitable for the intended end use.
- The written approval from Nilit to use the CORDURA® fabric brand on any specific certified fabric style is valid for 3 years. After this period, permission to use the brand would need to be requested again and new samples submitted for testing.
- NILIT may refuse the use of the CORDURA® fabric brand for low quality fabrics and garments.
- Hangtags, sew-in labels and all other forms of CORDURA® logo usage can be requested via our Internet site or from the contacts below. Details of the legal requirements of trademark usage are given on this Internet site. Unauthorized usage of the CORDURA® fabric trademark is subject to prosecution.

### **Disclaimer**

This Brand Requirement Certification document contains only selected data and further information on our Internet site should be carefully read. Customers using NILIT products are responsible for ensuring that it is suitable for the intended end use. Full information via [www.nilit.com/fibers](http://www.nilit.com/fibers).

### **Contacts**

**Headquarters:** NILIT Ltd. Maurizio Levi Rd. Ramat Gabriel, P.O.Box 276, Migdal Haemek, 2310201 ISRAEL.  
 Tel: + 972-4-654-4506 Fax: + 972-4-654-4636,

Branding Lab: Ilan Ben Akiva e-mail: [ilanb@nilit.com](mailto:ilanb@nilit.com)

Hangtags: Sigalit Nachmani e-mail: [sigalitn@nilit.com](mailto:sigalitn@nilit.com)

## **CORDURA® Fabric Branding Submission Form**

CORDURA is a registered trademark of INVISTA and is used under license by NILIT® for nylon products.

This brand submission form must be **completed and signed** and sent, along with the required fabric samples to the address below. If the fabric meets the required certification standard, an approval certificate with a unique fabric reference number will be sent to you.

**Suggestion:** Fill in this PDF form on your computer, print and save for future reference.

**Fabric Supplier Details**

Fabric Manufacturer Details: Manufacturer's Name _____ Address _____ _____ Country _____ Contact Name _____ Telephone _____ E-mail _____ Fax _____	Company name (if not the fabric manufacturer) _____ Address _____ _____ Country _____ Contact Name _____ Telephone _____ E-mail _____ Fax _____
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**Fabric Details**

Your fabric reference name/quality number \_\_\_\_\_

Is this the first time this fabric has been submitted for branding? Yes  No

Fabric type (please tick): Circular knit  Seamless  Woven  Knitwear

Ends/centimetre Warp (wales) \_\_\_\_\_ Weft (Courses) \_\_\_\_\_  
 Amount of coating \_\_\_\_\_ gm/sq.m Finished fabric width \_\_\_\_\_ cms  
 Greige fabric weight \_\_\_\_\_ gms/sq.m Finished fabric weight \_\_\_\_\_ gms/sq.m

Note: Warp knit fabrics should be submitted directly to INVISTA for certification.

**Yarn Details**

Each Yarn in the fabric	Yarn Details: (e.g. decitex, filaments, type)	Cordura® Yarn Purchased from:
CORDURA® fabric Brand Qualifier 1		
CORDURA® fabric Brand Qualifier 2		
Other yarn 1		
Other yarn 2		
Other yarn 3		

**CORDURA® Enduse (please mark)**

Outerwear wovens - lightweight	<input type="checkbox"/>	Outerwear wovens	<input type="checkbox"/>
Consumer Workwear - lightweight	<input type="checkbox"/>	Consumer Workwear – extreme & reinforcements	<input type="checkbox"/>
Ready to Wear	<input type="checkbox"/>	Knitwear	<input type="checkbox"/>
Denim	<input type="checkbox"/>	Motorcycles suits & reinforcements	<input type="checkbox"/>

Your signature \_\_\_\_\_ Date \_\_\_\_\_

Your signature is essential and by signing the request for brand certification, the signatory is legally bound by the Terms & Conditions of the CORDURA® fabric branding scheme (further details on the NILIT Internet site [www.nilit.com/fibers/hangtags](http://www.nilit.com/fibers/hangtags)).

Send this completed form together with two sock samples or with two metres of full width, finished fabric and half a metre of uncoated fabric to:

Nilit Branding Center  
 Nilit Ltd., Maurizio Levi Rd., Ramat Gabriel, Migdal Haemek, 2310201 ISRAEL  
 Contact: Mr. Ilan Ben Akiva, tel. 972-4-6544450 fax 972-4-6544449 e-mail: [ilanb@nilit.com](mailto:ilanb@nilit.com)